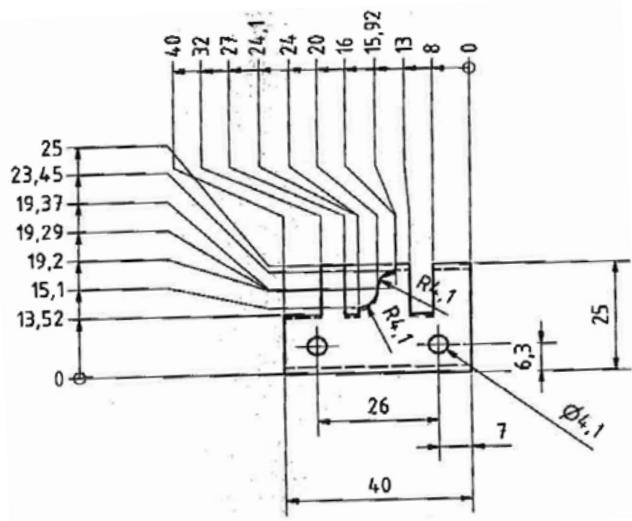


Removeable Insert

A09-010

Roughing of the profile is done in plunge grinding. Pregrinding and finishing of the profile is ground using standard 14EE1 Profilewheels and automatic calculation of the wheelorientation to achieve the required radial and axial clearance. Probing is measuring the reference of the insert - hole, side, ceration or other geometries - if necessary.



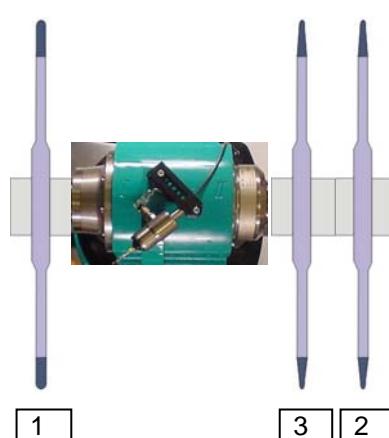
1. Cycletime for Production

Workpiece: 40 x 25, t = 2 mm Material CARBIDE			
Operations	Probe	Prf Rough	Prf Pgnd
Feed [mm/Min]	2000	100	80
Power [kW]		2	1
Cutting feed [m/s]		20	22
Used wheels	1	2	3
Grinding time [s]	20	280	52
Total cycle time	6 Min 35		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14F1 Ø200 D76R1.5
2	14EE1 Ø200 D76R0.8
3	14EE1 Ø200 D64R0.4



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories:

Responsable engineer: OP. 3.8.10

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